

4/6/2018

APR 09 2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-314

Job Sheet 175587



Part No: D206-642-314

Job Qty: 1 ea

Part Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/6/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV Q SHEETS 29-30 IPP REV:A 11.11.18 NEW ISSUE DD VERF:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/18/18	4/18/18	0.00	0.00	Start Up Stores/Pkg-1		APR 17 2018
110	Packaging	1 pcs	4/18/18	4/18/18	0.00	0.00	Packaging1-2		APR 17 2018
120	QC	1 pcs	4/18/18	4/18/18	0.00	0.00	QC4		DAS 58 9-89
125	DC	1 pcs	4/18/18	4/18/18	0.00	0.00	DC		DAS 58 9-89
130	Packaging	1 pcs	4/18/18	4/18/18	0.00	0.00	Packaging3-1		APR 18 2018
140	QC21-FG	1 Ea	4/18/18	4/18/18	0.00	0.00	QC21		APR 19 2018

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

125 - Document Control Photocopy bluefile and create labels per PPP D206-642-314 CHG001

130 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D206-642-314 Location:

PPP Rev: _____

140 - QC21- Final Inspection - Work Order Release



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S061739



Part: D206-642-314

Job No: 175587

Serial No/Batch: S061739

Revision:

Inspector:

Date: 04/17/18

S055511x1xRH

4/6/18 2:34 PM Dart.Gagnon.Michelle

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	S038750 ✓
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	S044186 ✓
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	S019407 ✓
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	S017095 ✓
AN5-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	S003927 ✓
AN5-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	S003926 ✓
D206-642-351	Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	S059444 ✓
D206-648-013	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	S059273 ✓
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	S043981 X5 S049899 ✓
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	S031303 ✓
D2932-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	S059232 ✓
D2933-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	F156174 ✓
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	S014622 ✓
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	S054582 ✓
D2938-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	S059232 ✓ F153835
D2939-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	S059232 ✓
D3407-043	Tow Ring	1 Ea (1 ea)	90-Start up Operation	F159457 ✓
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	F159722 ✓
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	S050328 ✓
D3457-1	Washer	2 Ea (2 ea)	90-Start up Operation	S035433 ✓
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	S038764 ✓
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	S045901 ✓
MS21043-4	Nut	1 Ea (1 ea)	90-Start up Operation	S038086 ✓
NAS1149C0463R Washer		1 Ea (1 ea)	90-Start up Operation	S019381 ✓
NAS1149D0363J Washer		8 Ea (8 ea)	90-Start up Operation	S015269 ✓
NAS1149D0463J Washer		24 Ea (24 ea)	90-Start up Operation	S045845 ✓
NAS1149D0563J Washer		8 Ea (8 ea)	90-Start up Operation	S039036 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	259	0
	AN4-6A	12	1,030	0
	AN4C5A	1	117	0
	AN5-10A	4	227	0
	AN5-11A	8	221	0
	AN5-12A	4	408	0
	D206-642-351	1	2	0
	D206-648-013	1	1	0
	D2652	16	1,000	0
	D2712	10	381	0
	D2932-2	1	0	0
	D2933-2	1	2	0
	D2934	2	82	0
	D2935	2	62	0
	D2938-2	1	1	0
	D2939-2	1	0	0
	D3407-043	1	11	0
	D3413-1	1	39	0
	D3456-1	1	131	0
	D3457-1	2	39	0
	MS21042L3	8	2,563	0
	MS21042L4	12	3,861	0
	MS21043-4	1	795	0
	NAS1149C0463R	1	324	0
	NAS1149D0363J	8	2,883	0
	NAS1149D0463J	24	5,730	0
	NAS1149D0563J	8	1,794	0

Part Specifications

Specifications could not be found.

Plex 4/6/18 2:34 PM Dart.Gagnon.Michelle

Change Record

PAGE 1 OF 1

Part Number: D206-642-313/-314

Description: SKIDTUBE , LH/RH

[illegible]

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1				X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12